

Work Order ID 54626

December 15, 2009 8:38:22 AM

Page 1

Item ID: PB67-43001-113

Accept

Setup Start

Revision ID:

Stop

Item Name: Square Tube

Start Date: 12/15/09 Start Qty: 2.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *CL*

Date: *09/12/15* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

0.00

0.00

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank as per dwg PB67-43001

0.00

0.00

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1- Mill as per Dwg B67-43001
DO NOT MILL 1.75" RAD

2- Deburr

0.00

0.00

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-113 PAR #: N/A Fault Category: Machine NCR: (Yes) No DQA: NA Date: 10-01-11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 10/01/20

NCR: <u>54626</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/19	110	dimension 3.07 off of .060" dimension 2.08 off of .060" just one side 2 piece.		- SCRAP Qty 2. - Replace Qty 2.	 09/22/10	 10/01/07		 LOS-12-21
		The incorrect bal size off set. Took a 0.750" measurement instead of 0.625". Re: WOA						 LOS-12-21

NOTE: Date & initial all entries

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Page 2

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Start Date: 12/15/09 Start Qty: 2.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA767 Rev: AA & Dwg B67-43001 Rev: C

2-Deburr per dwg B67-43001

140

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

150

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54626

December 15, 2009 8:38:22 AM

Page 3

Item ID: PB67-43001-113

Accept

Setup Start

Revision ID:

Stop

Item Name: Square Tube

Start Date: 12/15/09 Start Qty: 2.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/15/08 ①*10/01/08* *[Signature]**10-1-08*

②

+

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 15, 2009 8:38:22 AM

Page 1

Work Order ID: 54626



Parent Item: PB67-43001-113



Parent Item Name: Square Tube

Start Date: 12/15/09

Required Date: 12/18/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 5		Purchased	No			100	f	0.0000	3.8947			



6061T6 SQ TUBE 1.00 x 1.00 x .125w

M 110680 4 ft SA 06/12/15
+ 45" for scrap parts.

8/10/01/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 54626
Description: SQUARE TUBE	Part Number: B67-43001-113
Inspection Dwg: B67-Box Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

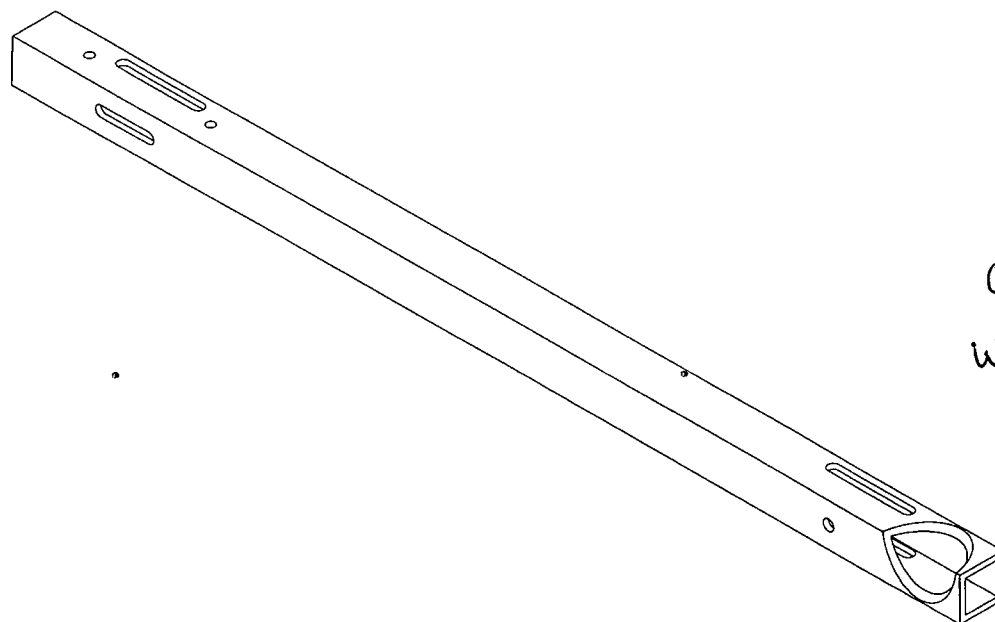
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.725	$\pm .010$.722	✓			
.500	$\pm .016$.497	✓			
1.30	$\pm .030$	1.295	✓			
2.84	$\pm .030$	2.839	✓			
Ø.194	$\pm .005$	Ø.195	✓			
1.88	$\pm .036$	1.882	✓			
1.750	$\pm .010$	1.750	✓			
.250	$\pm .010$.250	✓			
1.750	$\pm .010$	1.750	✓			
1.93	$\pm .030$	1.929	✓			
1.79	$\pm .030$	1.796	✓			
.09	$\pm .036$.095	✓			
.500	$\pm .030$.500	✓			
.250	$\pm .010$.250	✓			
2.08	$\pm .030$	2.14	✓	✓		2.087 2.087 SF 10/01/05
1.100	$\pm .010$	1.100	✓			
22.20	$\pm .030$	22.200	✓			
Ø.250	$\pm .005$	Ø.250	✓			
3.07	$\pm .030$	3.130		✓		3.065 SF 10/01/05
.04	$\pm .036$.040	✓			

Measured by: SP
Date: 10/12/07

Audited by: <i>Amf</i>
Date: 10/10/07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



C209/12/15
W/O: 54626

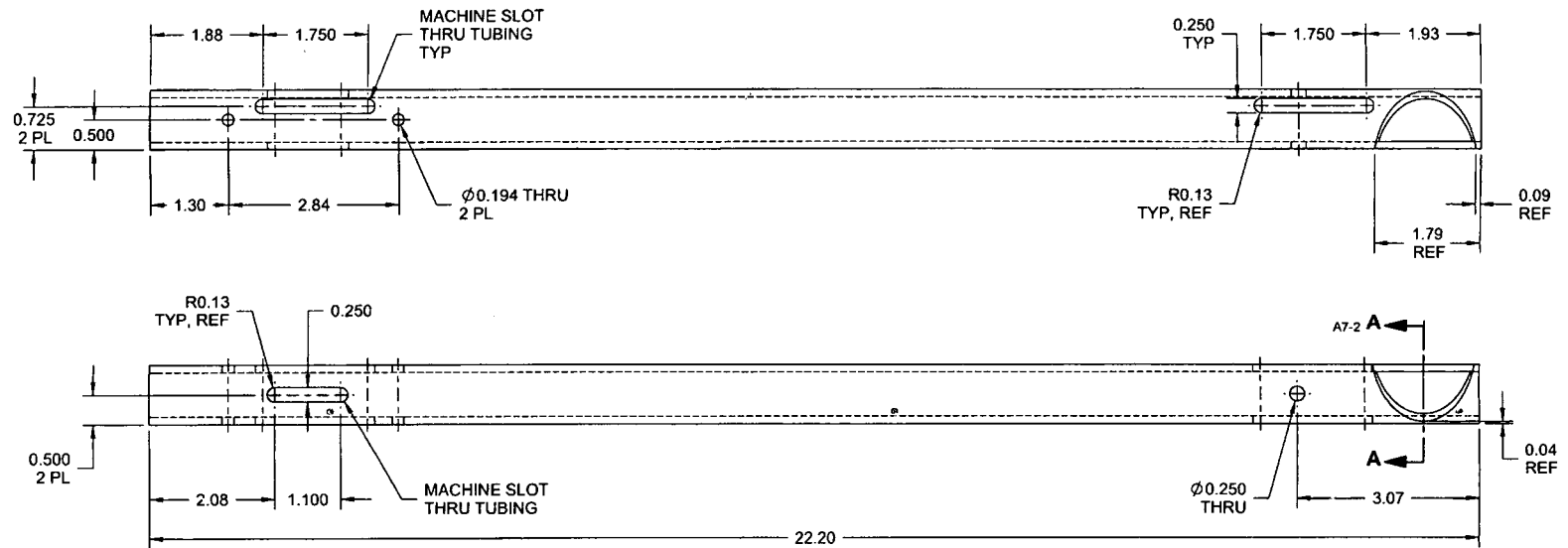
B67-43001-113 SQUARE TUBE

RELEASED
2009-09-24
ND

NOTES:

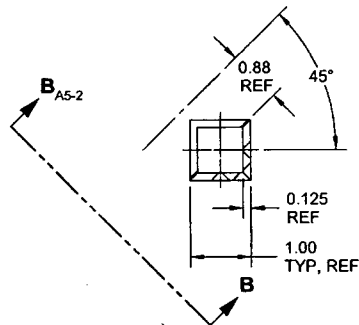
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.89 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 33 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.18
REV.	DESCRIPTION		BY	DATE
DESIGN	RW		DART AEROSPACE LTD	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED	123		DRAWING NO.	REV. C
MFG. APPR.	Gib		B67-43001-113	SHEET 1 OF 2
APPROVED	Gib		TITLE	SCALE
DE APPR.	N/A		SQUARE TUBE	NTS
DATE	09.02.18		<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

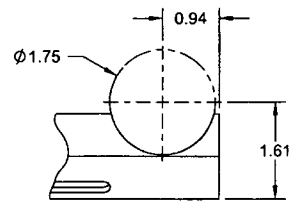


B67-43001-113 SQUARE TUBE

C 209112/15
W10:54626



SECTION A-A C2-2



VIEW B-B B8-2
ROTATED 45° CCW

RELEASED
2009-09-24
NW

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	153	DRAWING NO.	REV. C
MFG. APPR.		B67-43001-113	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
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